

Work Order ID 59394

Thursday, June 03, 2010 12:40:02 PM



Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 6/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-6-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4030

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/06/24

P 10/6/22 (1)

P 10/06/24 (2)

(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

w/ 13 59398

Memo

0.00

Packaging

D350-607-441

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 10-6-30

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Picklist Print

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Page 1

Work Order ID: 59394

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC






IPP Rev:B as






Start Date: 6/3/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D2530 Handle Weldment		Manufactured	No			100	Each	1.0000	1				
<div> <div>Location</div> <div>ST506</div> <div>58428</div> </div> <div> <div>Loc Qty</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
 D2535 Spring		Manufactured	No			100	Each	126.0000	2	2			
<div> <div>Location</div> <div>ST504</div> <div>56355</div> <div>58331</div> </div> <div> <div>Loc Qty</div> <div>126</div> <div>26</div> <div>100</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
 D2537 Bushing		Manufactured	No			100	Each	31.0000	4	4			
<div> <div>Location</div> <div>ST504</div> <div>58429</div> </div> <div> <div>Loc Qty</div> <div>31</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
 D3913-041 Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1				
 D3914-041 Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1				

 1
 2
 4
 1
 1

510/06/24
 B59154
 56355
 58429
 510/06/24
 510/06/24

B59397
 B59396

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D3917-3 Washer		Manufactured	No			100	Each	49.0000	6	6			

Location Loc Qty Loc Code

ST096

49

57144

1

58892

48

D3953-3
Gas Spring Stud, Lid

Manufactured

No

100

Each

13.0000

2

Location Loc Qty Loc Code

ST102

13

58894

13

D3953-7
Spring Spacer

Manufactured

No

100

Each

13.0000

2

Location Loc Qty Loc Code

ST103

13

58893

13

D3953-9
Gas Spring Washer

Manufactured

No

100

Each

9.0000

2

Location Loc Qty Loc Code

ST101

9

53642

9

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Page 2

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3953-17 Gas Spring Spacer		Manufactured	No			100	Each	9.0000	2	2 ✓			

Location Loc Qty Loc Code

ST101 9
57143 1
58857 8

D3953-19 Gas Spring Bracket Manufactured No 100 Each 18.0000 1

Location Loc Qty Loc Code

ST 14
59213 14
ST101 4
57607 4
ST103 14

D3953-21 Gas Spring Bracket Manufactured No 100 Each 29.0000 1

Location Loc Qty Loc Code

ENG 5
56407 5
ST102 24
57145 7
59214 17

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3969-3 Spring (Basket Lid)		Manufactured	No			100	Each	4.0000	1	1			

Location Loc Qty Loc Code
ST 4

56386 4

AN3-14A Purchased No

100 Each 58.0000

4

4

Bolt

Location Loc Qty Loc Code
ST351 58

114330 58

AN3-16A Purchased No

100 Each 151.0000

2

2

Bolt

Location Loc Qty Loc Code
ST352 151

113845 31

114523 20

114752 100

AN5-17A Purchased No

100 Each 165.0000

4

4

Bolt

Location Loc Qty Loc Code
ST323 19

114324 19

ST339

146

114330 100

114784 46

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AN4-12  Bolt		Purchased	No			100	Each	70.0000	3	3																		
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST357</td><td>70</td><td></td></tr><tr><td>114292</td><td>20</td><td></td></tr><tr><td>114784</td><td>50</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST357	70		114292	20		114784	50				
Location	Loc Qty	Loc Code																										
ST357	70																											
114292	20																											
114784	50																											
AN310-4  NUT		Purchased	No			100	Each	49.0000	3	3																		
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST324</td><td>44</td><td></td></tr><tr><td>114716</td><td>44</td><td></td></tr><tr><td>ST349</td><td>5</td><td></td></tr><tr><td>114341</td><td>5</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST324	44		114716	44		ST349	5		114341	5	
Location	Loc Qty	Loc Code																										
ST324	44																											
114716	44																											
ST349	5																											
114341	5																											
AN310C4  Nut		Purchased	No			100	Each	60.0000	2	2																		
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST349</td><td>60</td><td></td></tr><tr><td>114306</td><td>60</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST349	60		114306	60							
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ST349	60																											
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Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

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IPP Rev:B as

Start Date: 6/3/2010

Required Date: 6/14/2010



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			100	Each	3,520.000	6	6			
													
Nut													



Location	Loc Qty	Loc Code
ST300	3520	
113537	20	
114523	1000	
114718	500	
114784	2000	

114523

MS21042L5		Purchased	No			100	Each	932.0000	4	4			
													
Nut													

Location	Loc Qty	Loc Code
ST139	500	
114813	500	
ST300	432	
114437	36	
114449	396	

114449

MS24665-151		Purchased	No			100	Each	656.0000	3	3			
													
Cotter Pin													

Location	Loc Qty	Loc Code
ST309	656	
17566	656	

17566

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Page 6

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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS24665-300		Purchased	No			100	Each	70.0000	2	2			


Cotter Pin

Location Loc Qty Loc Code

ST309 70
105279 2
110123 68

NAS1149F0432P Purchased No

100 Each 651.0000 6


Washer

Location Loc Qty Loc Code

ST275 651
112940 92
114405 1
114576 58
114718 500

NAS1149F0563P Purchased No

100 Each 232.0000 4


Washer

Location Loc Qty Loc Code

ST275 32
108471 32
ST298 200
114576 200

7/10/23
6

7/14/28
4

108471

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NAS1149F0332P		Purchased	No			100	Each	779.0000	8	8			
WASHER													

Location Loc Qty Loc Code

ST275 779

18057 779

NAS1149C0432R Purchased

No

100 Each

762.0000 2



Washer

Location Loc Qty Loc Code

ST297 762

114292 162

114742 600

18057

2

114292

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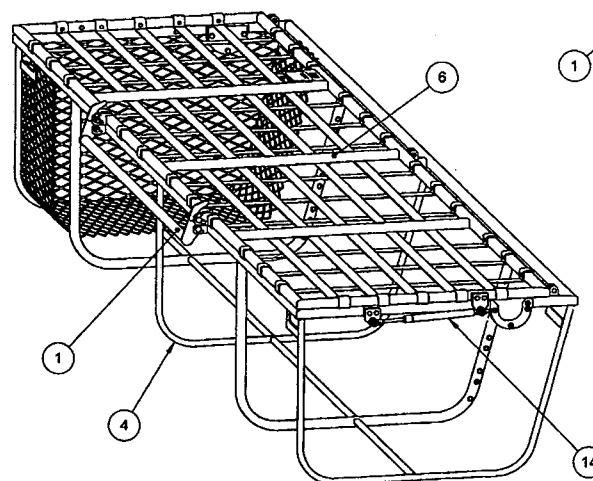
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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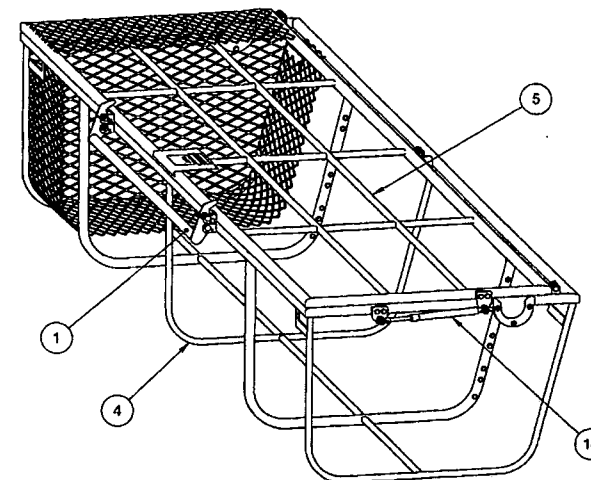
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8		NAS1149F0332P	WASHER
31	2		NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 59397

B-10-6-03

RELEASED
2010-04-14

B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.08
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	AWP		
DE APPR.	AWP		
DATE	10.04.06		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4030 TITLE LONG BASKET ASSY (350) REV. B SHEET 1 OF 3 SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

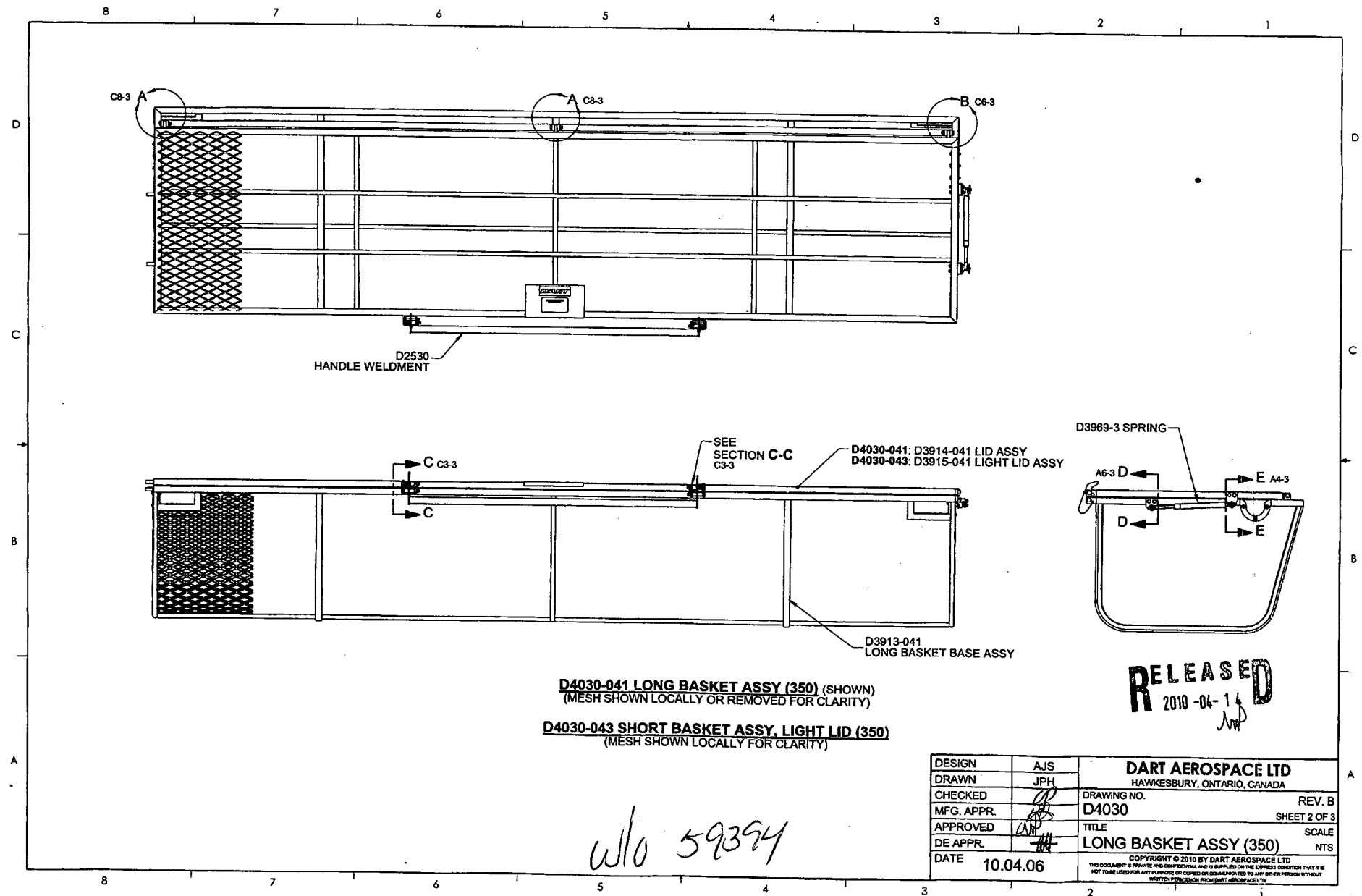
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

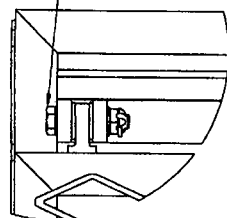
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

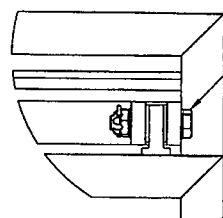
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

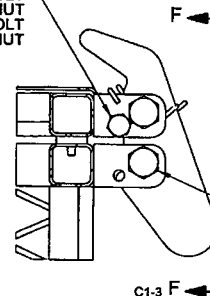


DETAIL A D8-2
D5-2



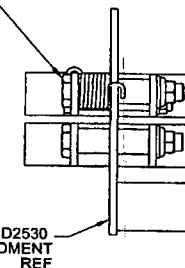
DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
2010-04-14
MP

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W0 59394

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries